

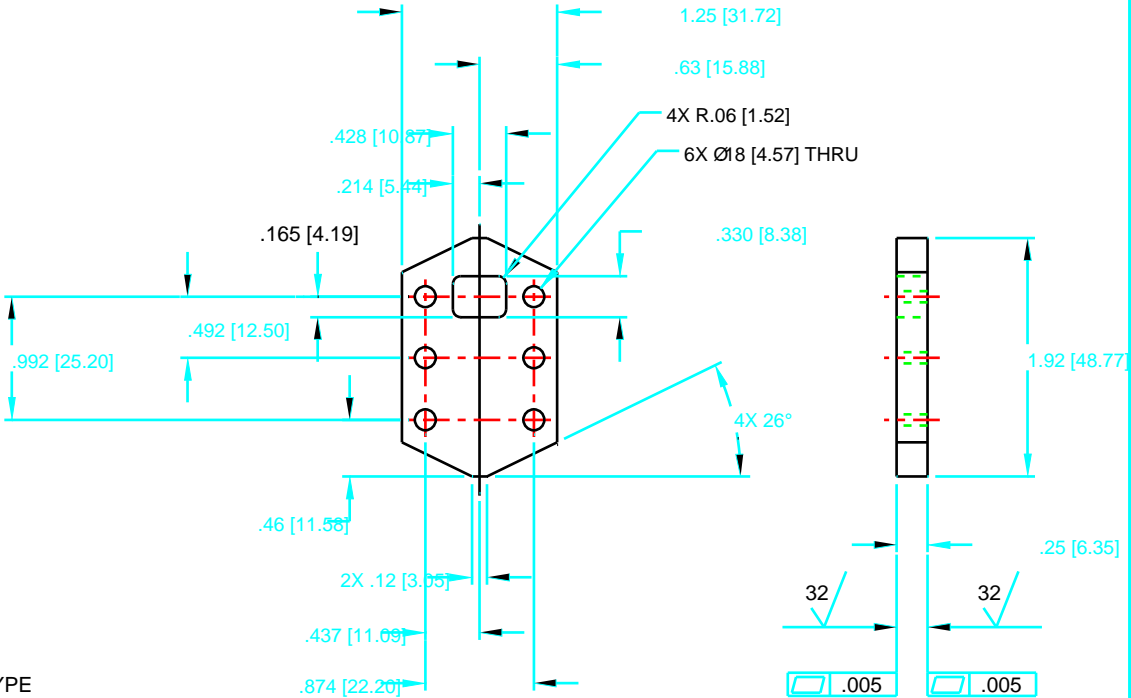
NOTES:

1. TUNGSTEN ALLOY OF 95% TUNGSTEN OR MORE WITH REMAINDER OF NICKEL AND IRON PER MIL-T-21014D CLASS 3, UHV GRADE
2. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
3. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL
4. ALL SURFACES MUST BE MACHINED FOR CLEAN UP
5. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
6. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF  $1 \times 10^{-9}$  TORR CAN BE ACHIEVED
7. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
8. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY

REF. SOURCE

MITEK METALS, INC.  
1340 NORTH SENATE AVE.  
INDIANAPOLIS, IN 46202  
TEL: 1-317-637-3574  
FAX: 1-317-633-7224

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				



ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER	THIS DRAWING IS THE PROPERTY OF	
TOLERANCES		P4510103-00	ARGONNE NATIONAL LABORATORY	
DECIMALS	ANGULAR	DRAWN BY	DATE	TITLE
.X - .1 [2.5]	- 0°30'	MUSCIA	10/16/98	ADVANCED PHOTON SOURCE
.XX - .01 [0.25]		CHECKED BY	DATE	P4-50 INTEGRAL SHUTTER
.XXX - .005 [0.13]		J. CHANG	11/25/98	FOR 32-ID-A
SURFACE ROUGHNESS 125		DESIGNER	DATE	WHITE BEAM STOP
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		CHANG/MUSCIA	10/16/98	RADIATION GUARD
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		RESPONSIBLE ENGINEER	DATE	
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		J. CHANG	11/25/98	
DO NOT SCALE DRAWING		MATERIAL	SCALE	SIZE
		SEE NOTE #1	1:1	B
			SHEET 14	DRAWING NUMBER
				P4-510103-00